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REYNOLDS ALUMINUM COMPANY

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INFORMATION CENTER

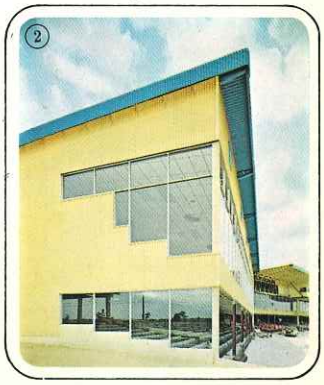
Reynolds Aluminum

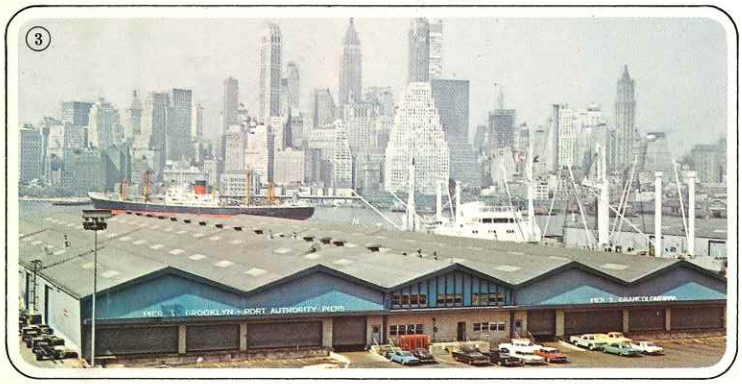
AIA File No. 12-C

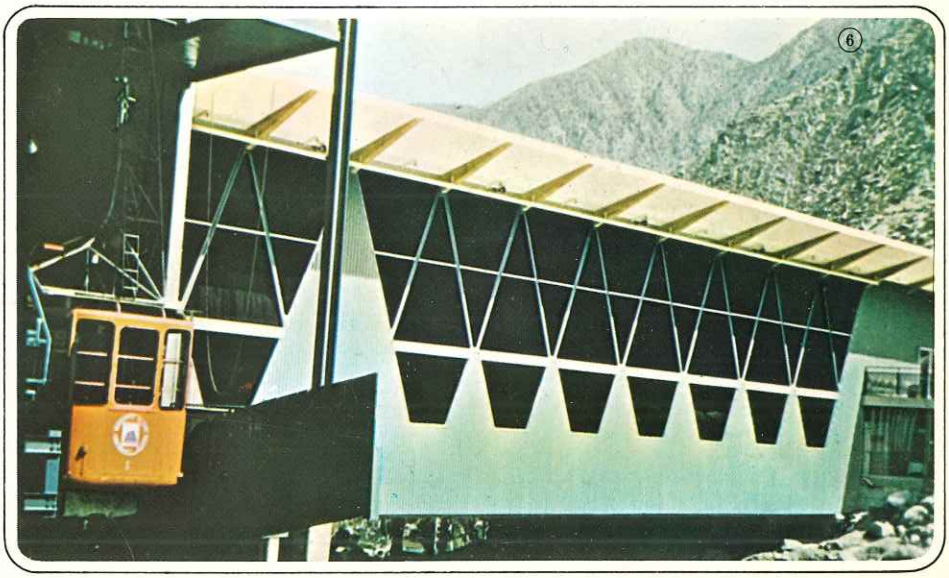
colorweld® colors

490
Wood

Reynolds Aluminum Commercial Building Products with COLORWELD color finishes are proven-in-use throughout America







Reynolds Aluminum Commercial Building Products featurin

DESCRIPTION Reynolds Commercial Building and Siding Products are available in the eight standard COLORWELD colors shown. COLORWELD is a pre-enameled aluminum sheet having all the advantages of natural aluminum plus the design latitude of color, and the added durability of the COLORWELD finish.

Enamel is applied by the reverse roll-coat method. A chemical conversion pre-paint coat on the aluminum assures a durable bond for the final color application. Cleaning, alodining, roller-coating and baking are handled in a continuous process in which coiled sheet unrolls at one end and emerges as a completely coated and finished sheet at the other. This is done under meticulous control and almost complete freedom from contamination by foreign matter. Color sensing devices are used to maintain precise color uniformity.

ADVANTAGES You buy beauty, color, and lasting durability, and at only pennies more per square foot than for unpainted aluminum.

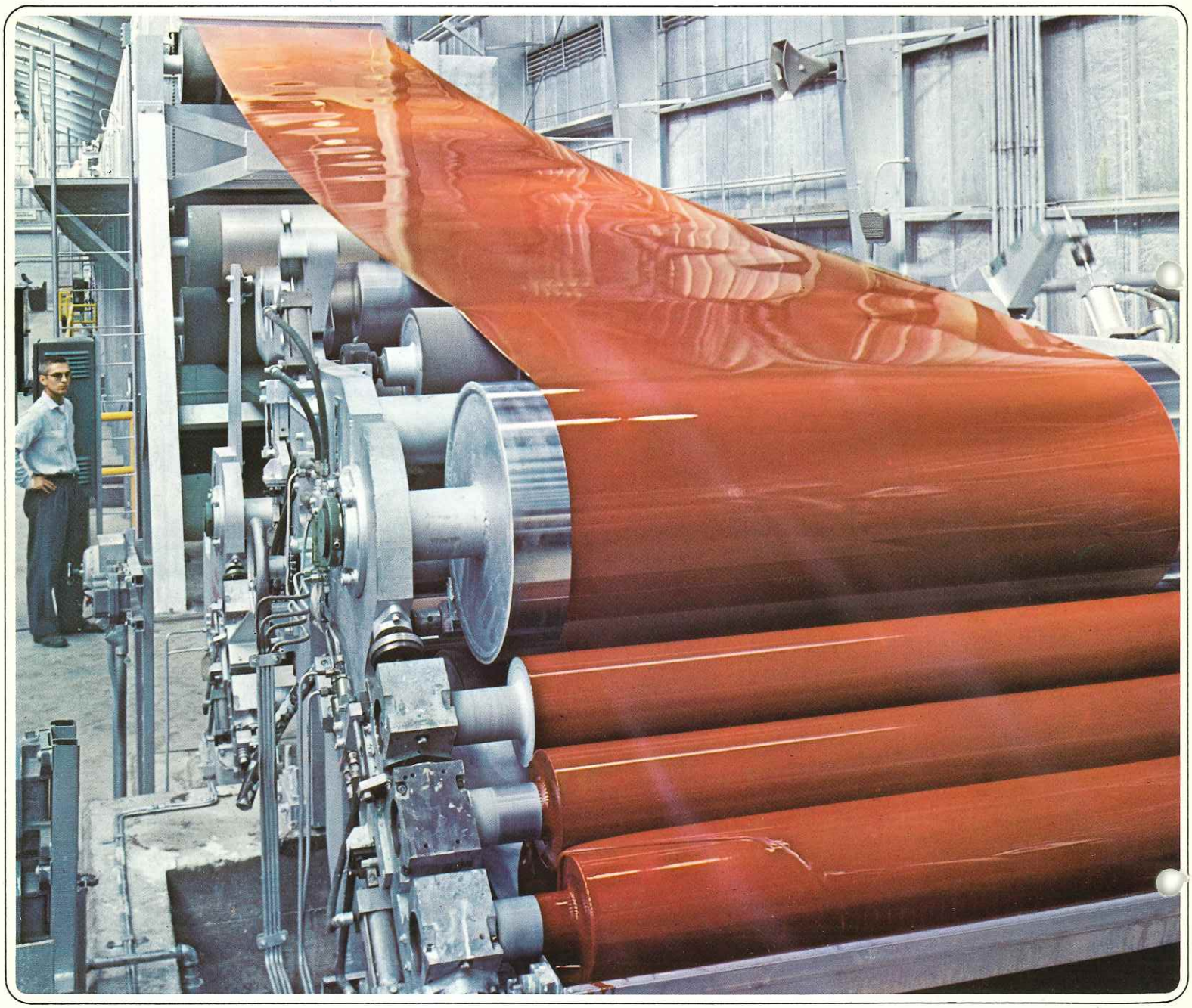
The tough resilient enamel coating allows COLORWELD enamel flashing sheets to be locally fabricated.

Ordinary manufacturing or field-applied coloring processes subject the product to human error to a much higher degree than does the Colorweld process. These problems are: possible poor preparation of metal, or contamination prior to painting, variations in coverage and damage to product while handling through ovens.

COLORWELD combines the very latest in precision automation and quality color control. Mass-production efficiency and economy plus a new, physically tougher finish makes possible uniform pre-coloring of flat aluminum sheets BEFORE product forming. Contamination and variation are eliminated. Regardless of end product configurations there are no thick and thin color variations, no breaks in color coverage.

Here is color that won't peel, crack, blister or mildew... provides maximum resistance to abrasions and scuffing... absorbs severe shock or deep dents without chipping or spalling... is chemically inert to common acids, alkalies and salts... will not rust or undercut when film is broken by drilling for fasteners or other fabrication.

Aluminum, the finest paints available, and the latest manufacturing processes by



Colorweld coil is made in a completely automatic, three-step process, with electronic controls to assure color uniformity.

g Colorweld: aluminum plus color for durability and beauty

Reynolds combine for unbeatable quality.

To be first with the finest...side with Reynolds!

PROCESS A de-coiler straightens the unpainted coils of natural aluminum which continuously feed into the intricate COLORWELD machine, as rolls of paper are fed into highspeed printing presses. Untouched by human hands, the sheet travels at the rate of 100 feet per minute on its completely automated quarter mile journey. A series of chemical de-greasers, surface preparations and cleaning baths eliminate every source of contamination. Now absolutely clean and properly prepared for perfect color adhesion, the flat aluminum sheet continues through a series of coating rollers to receive the smoothest, most uniform color coverage possible.

On into the baking ovens, the color becomes permanently welded to the aluminum . . . perfect bonding is assured. Although the precision machinery assures highest quality control, all coils are subjected to continuous rigid scientific inspection and sampling. You can always be sure of the same uniform, constant color.

The pre-colored sheets are recoiled and placed in protected storage areas, ready for product forming. Eight standard colors, in various gauges and widths and configurations, are available to meet the most stringent requirements for beautiful, functional designs.

The flat pre-colored sheets are later subjected to fabricating pressures exceeding a ton. The tough COLORWELD film withstands these torturous operations of embossing and forming...proof that COLORWELD colors can really take it!

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USES These bright medium gloss colors can be attractively combined with the contrasting colors and textures of other materials for pleasing architectural effect.

The eight standard COLORWELD colors are available in all Reynolds siding configurations except Commercial Corrugated in Stucco-Embossed finish only. In addition they are also available in Stucco-Embossed finish flat flashing sheet for field forming to individual job requirements.

These can be used as contrasting trim to other COLORWELD siding colors, or to enhance the natural beauty of aluminum with a color accent.

Choose from 8 handsome COLORWELD colors

Polar White

Mint Green

Desert Beige

Dawn Blue

★ Driftwood Gray

★ Heron Blue

★ Vivid Cream

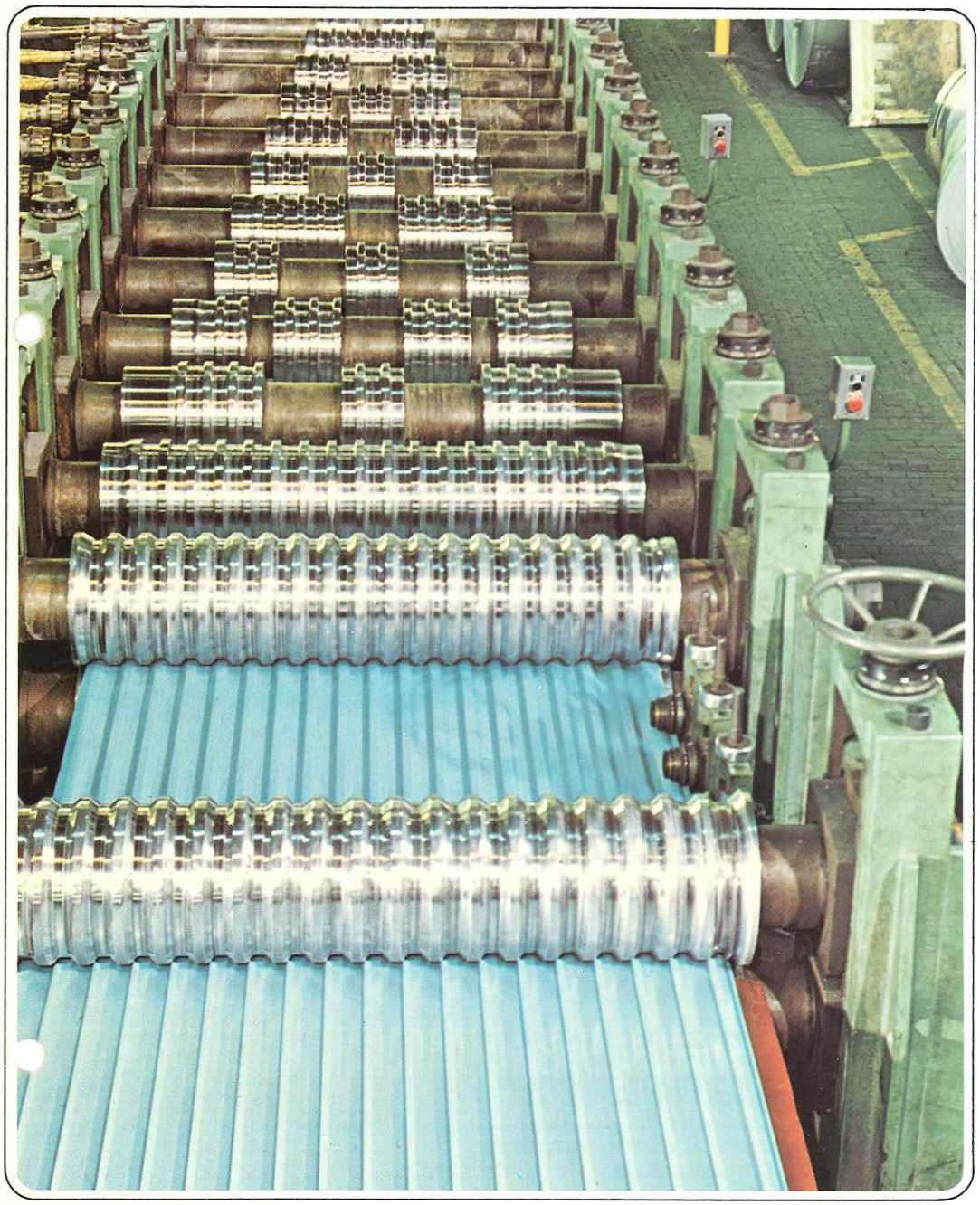
★ Terra Cotta

★ Subject to special inquiry for V-Beam and 8″ Rib.

These standard COLORWELD medium gloss colors are available on aluminum sheet in a range of gauges, widths, and configurations.

Matching Colorweld Flashing Available

Flat sheets of stucco-embossed COLORWELD flashings are available for fabricating and cutting in the field to satisfy the exact requirements of each job.



Baked-on enamel coating on Colorweld is tough enough to take a ton of pressure without cracking or crazing.

Suggested COLORWELD Specifications

All siding and/or roofing covered by this specification shall be finish painted as herein specified by the Reynolds Metals Company, such that no field painting shall be required except for touch-up of scuffs and scratches which may occur during erection.

The aluminum shall receive, prior to painting, a conversion coating specifically formulated as a pre-paint treatment for aluminum. A protective back-coating shall be applied to the reverse side. The conversion coating, the back-coating, and all paint shall be applied in one continuous process, starting with unpainted coiled aluminum and ending with painted coiled aluminum. The finish paint shall be applied by the reverse roll-coat method and shall be oven baked. The dry film thickness of the paint shall be 1 mil (plus or minus 0.2 mil). The finish shall be of such quality that all shearing, embossing, or forming may be done after painting without damage to the surface or separation of the finish from the aluminum. The paint finish shall be free from sagging, streaking, or visible "orange peel." The paint finish shall meet the following requirements (method numbers indicated are per the latest issue of Federal Testing Methods Standards No. 141):

GLOSS RANGE (Method #6101 of Federal Test Method Standard #141 and ASTM D523-53T)—specular gloss shall be 30 units, plus or minus 8 units, on a 60-degree photovoltmeter unless otherwise specified.

HUMIDITY RESISTANCE (Method #6201 and JAN-H-792)—humidity resistance, 2000 hours of 100% relative humidity with the cabinet at 100°F. Film to reveal no change and be free of blistering.

SALT SPRAY RESISTANCE (Method #6061 and ASTM B117-61)—1000 hours in 5% salt spray. No corrosion creepage or blistering from the score line shall exceed 1/32".

WEATHEROMETER (Method #6152 and ASTM D822-60)—National Carbon Arc Weathering Test, 2R cycle, 110 minutes ultraviolet exposure, 10 minutes ultraviolet plus water exposure. Finish shall reveal only very slight fading and slight chalking after 1000 hours.

WATER IMMERSION TEST (Method #6011)—a test panel exposed by immersion in distilled water at 100°F for 100 hours shall upon immediate withdrawal be free of checking, blistering, or peeling of the coating.

Cover Photos: 1. Reynolds Metals Company White Bear Can Plant, White Bear, Minn. 2. Southland Greyhound Park, West Memphis, Arkansas. 3. Pier #3, Brooklyn Port Authority, Brooklyn, New York. 4. Commerce Park, Danbury, Conn. 5. Beattie Plant of Woodside Mills, Fountain Inn, South Carolina. 6. Aerial Tramway, Palm Springs, California.

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